



Chemlon® 104-13 G

Teknor Apex Company - Polyamide 66

General Information

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Filler / Reinforcement	• Glass Fiber, 13% Filler by Weight
Additive	• Impact Modifier
Features	• Impact Modified
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Melt Mass-Flow Rate (MFR) (285°C/2.16 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow	4.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	14000	psi	ASTM D638
Tensile Elongation (Yield)	5.0	%	ASTM D638
Tensile Elongation (Break)	7.0	%	ASTM D638
Flexural Modulus	550000	psi	ASTM D790
Flexural Strength	19500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	2.5	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	419	°F	ASTM D648
Melting Temperature	495	°F	DSC
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	280	V/mil	ASTM D149
Comparative Tracking Index (CTI)	500	V	UL 746A
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
FMVSS Flammability	PASSES		FMVSS 302

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	465 to 495	°F
Middle Temperature	495 to 525	°F
Front Temperature	505 to 540	°F
Nozzle Temperature	505 to 535	°F
Processing (Melt) Temp	505 to 535	°F